

WHAT IS CLAIMED IS

1. A method for the manufacture of fluted rolls, in particular for corrugating machines, comprising the following steps:
 - 5 - providing a fluted-roll blank (41) with a central longitudinal axis (44) and with a longitudinal direction (43) that is parallel thereto and with a surface (42);
 - providing a grinding device (21) for grinding, on the surface (42), flutings (7, 8) that run in the longitudinal direction (43);
 - 10 -- the flutings (7, 8) comprising fluting heads (15) and roots (18) that are parallel to each other and are regularly and alternately distributed along the circumference of the surface (42); and
 - grinding fluting heads (15) on the surface (42) by means of the grinding device (21),
 - 15 -- the fluting heads (15) having the same cross-sectional curvature in the longitudinal direction (43).
2. A method according to claim 1, wherein the fluted-roll blank (41) has a diameter that varies in the longitudinal direction (43).
- 20 3. A method according to claim 1, wherein the fluted-roll blank (41) has a swell.
4. A method according to claim 1, wherein a grinding wheel (27) that is
- 25 displaceable in the longitudinal direction (43) is used in the grinding device (21).

5. A method according to claim 4, wherein a grinding wheel (27) is used, having two radially projecting annular beads (33, 34) and an annular recess (35) that is disposed there-between and stands back radially.

5 6. A method according to claim 5, wherein the annular recess (35) corresponds in cross-sectional shape to the curvature of the fluting heads (15).

7. A method according to claim 4, wherein the grinding wheel (27), upon grinding, is set to the surface (42) of the fluted-roll blank (41).

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8. A method according to claim 1, wherein the grinding device (21), upon grinding of the fluting heads (15), grinds a part of the two roots (18) that adjoin the heads (15).

15 9. A fluted roll, in particular for a corrugating machine, comprising

- a fluted-roll basic body which has a central longitudinal axis (44) and a longitudinal direction (43) parallel thereto and a surface (42); and
- flutings (7, 8) which are provided on the surface (42) and regularly

20 distributed along the circumference thereof and which run in the longitudinal direction (43),

- with the flutings (7, 8) comprising fluting heads (15) that project radially and roots (18) that stand back radially, the heads (15) and roots (18) being parallel to each other and alternating;

25 - wherein the fluting heads (15) have the same cross-sectional curvature in the longitudinal direction (43).

10. A fluted roller according to claim 9, wherein each fluting head (15) has a crest (16) of maximum distance from the central longitudinal axis (44),

with a respective crest (16) and the central longitudinal axis (44) defining a common plane.